

Date: Monday, 26/05/2008 1:12:06 PM
 User: Linda Lacelle

Process Sheet

OK

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FRONT LEG FITTING ASS'Y
 Job Number : 39487
 Estimate Number : 13342
 P.O. Number :
 This Issue : 26/05/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : R & D LG FAB
 Previous Run :
 Written By : M 08/05/20
 Checked & Approved By :
 Comment : Est Rev:A 08-05-20 new issue DD verified by:ec

Part Number : D3762041
 Drawing Number : D3762 PROTO
 Project Number : IA0004
 Drawing Revision : PROTO
 Material :
 Due Date : 02/06/2008 Qty: 4 Um: Each

Additional Product

PROTOTYPE

Job Number:



FOR ENGINEERING USE ONLY

Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
2.0	D37621	Fitting
	Comment: Qty.: 2.0000 Each(s)/Unit Total : <u>8</u> 2.0000 Each(s) Fitting batch: <u>B39486</u> → <u>6</u> <i>Cpl 08.05.29</i> (4)	
3.0	D37623	Tube
	Comment: Qty.: 1.0000 Each(s)/Unit Total : <u>4</u> 1.0000 Each(s) Tube batch: <u>B39470</u> <i>Cpl 08.05.29</i> (4)	
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
	Comment: LARGE FABRICATION RESOURCE 1 1-make a 0.063" chamfer on D3762-1 fitting before ass'y 2-assemble as per dwg D3762 using locating pin DT <u>9014</u> 3-weld as per dwg D3762 QSI004 Alum. rod Batch: <u>m106834</u> <i>Cpl 08.05.29</i>	

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Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/05/29 (4) 3
PTD
06.05.21

6.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

PTD
06.05.30

7.0

PACKAGING 1

PACKAGING RESOURCE #1



FOR ENGINEERING USE ONLY



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and ~~Stock~~
Location: _____

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.06.01 Perry

Job Completion



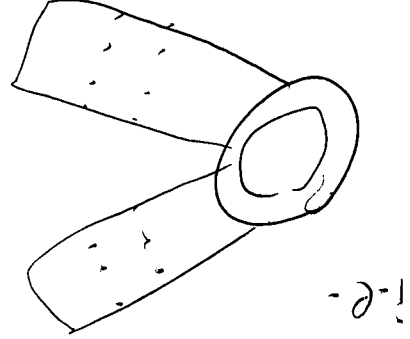
Charge to W/O # 00196

4.08.06/1

③ 08-05-30 / SK
 5.5 Chemical conversion coat per ASI 4.1
 5.5.1 Inspect chemical conversion coat
 08-05-30 X3

Discovered that holes on P36A-1 were drilled incorrectly

by 90°



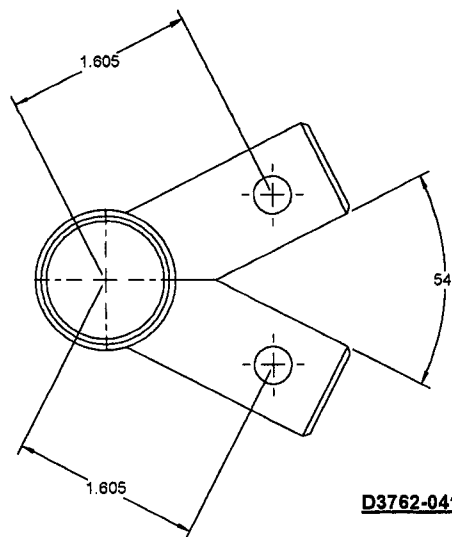
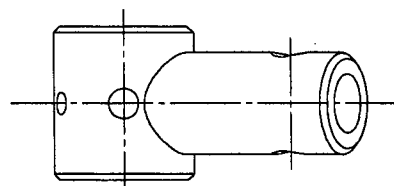
Sol'n

Drill correct holes

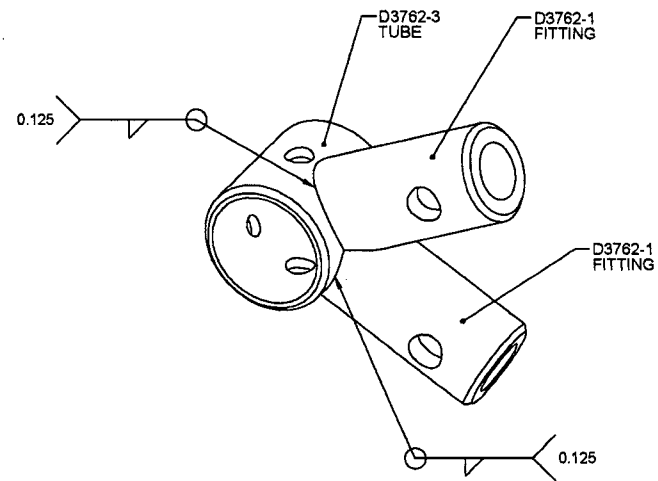
Keep as is

ACCEPTABLE DEVIATION
 08.05.30

08-05-30 / SK



D3762-041 FRONT LEG FITTING ASSY

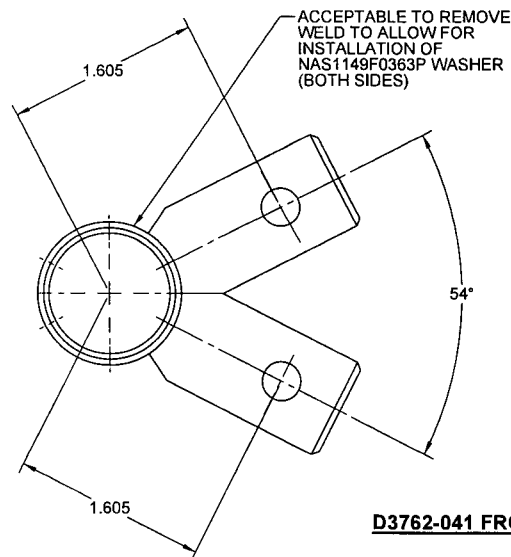
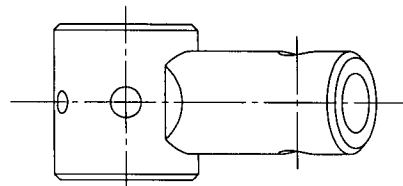


PROTOTYPE
SUPERCEDED

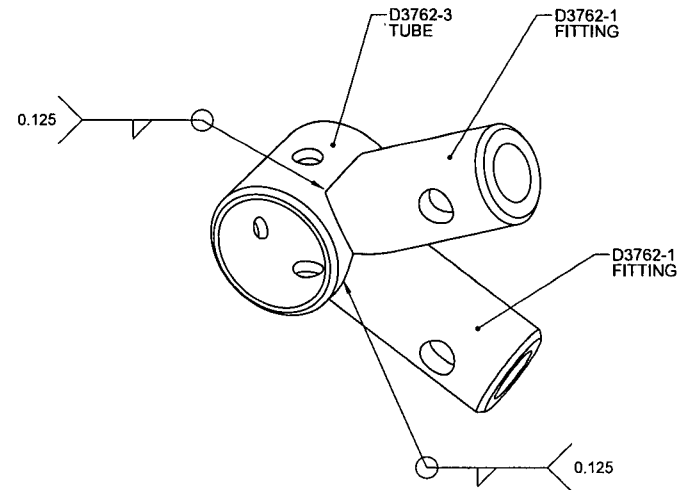
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs
- 8) WELD: PER DART QSI 004

REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3762	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FRONT LEG FITTING	1:1
DATE	08.05.22	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3762-041 FRONT LEG FITTING ASSY



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 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.06 lbs
 - 8) WELD: PER DART QSI 004

PROTOTYPE
06.05.30
P
J

A		NEW ISSUE		HS	08.05.22
REV.	DESCRIPTION			BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	HS				
CHECKED		DRAWING NO.	REV. A		
MFG. APPR.		D3762	SHEET 1 OF 3		
APPROVED		TITLE	SCALE		
DE APPR.		FRONT LEG FITTING	NTS		
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